Work Orde June-24-13 2:1	er ID 10367 1:49 PM	79		*10	36	79*					Page 1
Item ID: Revision ID: Item Name:	D2327-3 Spacer Bushing			Accept	*	<b>1</b> 900	<b>040</b>	100	)* s	etup Star Stop	11177
Start Date: Required Date: Reference:	6/24/13 St	eq'd Qty: 40.00	*40* *40*			Cust Item II Customer:	D;				
Approvals:		MLJ		Tooling: SPC (Y/N):			ite:		F	tun Star Stop	"NR I
Sequence ID/ Work Center I		peration escription		Set Up/ Run Hours		Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
Draw Nbr	Revisio	n Nbr				· · · · · · · · · · · · · · · · · · ·					•
D2327	Rev D										
*100 *100* Hardinge Hardinge CNC Late		nrdinge CNC LATHE S Memo Turn per Fol	SMALL io FA232 and Dwg D2327	0.00 0.00 Deburr	S 1 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0	13/07/	ંજ		40	Ø	
110 *110* QC Quality Control	QC	C2- Inspect parts off m  Memo	achine FAI/FAIB	0.00	5	13/07/	1°C.		40	Ø	
120 *120* oc	QO	C8- Inspect parts - seco	and check	0.00	\	3-1-2			40	Ø	

Quality Control

DQA:	···		Date:									DA PT	
						WORK ORDER NON	-C(	ONFO	RMANCE / UI				AEROSPACE
QA Closed:			Date:							<u> </u>	Nork Order ι	pdate only	
Work Orde	er:					DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			-		_	Rework Skid-tube Crosstube V			Water Jet	Engineering			
Part N	lo.					Scrap			Machining	Small Fab	Pro	od. Eng. Coor.	Quality
						Use-as-is		i	noforming	Finishing		ore/Packaging	Other
NCR N	۱o					Suspected Unapproved			Large Fab	Composite		Supplier	
-							•						
Root					Desci	ription of work order update	١	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Operator	$\dashv$												
Offset/Setup	$\vdash$											1	
Process							ءِ						
Supplier						š.							
Training Transport									1				
Unapproved	$\dashv$												
энаррготеа	<u></u>	1		LI			FΔI	ΠΤ CΔ	L TEGORY	<del></del>		.!	
Landir	ng Gear	r				General		-		<u> </u>			<del></del>
ĺ		nding				Bend		Folio/P	rogram	Г	Outside Dir	nensions [	Pressure/Forced
	Cer	ntre No	t Concen	ntric		BOM/Route		Grain	J	<u> </u>	Over/Unde	<u></u>	Set-up
	Cra	icks				Broken/Damage/Defect		Hardwa	re		Part Incorre		Temperature/Cure
	Cri	mp/Kin	k/Ripple,	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/M	lissing	Weld
•	Cuf	ffs				Contamination		Instruct	ions Incomplete/U	Inclear	Part Moved		Wrong Stock Pulled
	Cru	ıshing				Countersink		Misalig	ned/off center		Positioned	Wrong	<b></b>
	He	at Treat	t			Cut Too Short		Mislabe	eled		Power Loss	/Surge	Other
	_	•	Strip in	Tube		Drawing		Misread	d	_			
	Ма	irks/Cha	atter			Drill Holes		Off-set					
	Tur	rning Se	equence			Finish		Out of (	Calibration				
	l Iwa	ve/Twi	st in Tuh	e		Fit/Function		Out of	Saguanca				

Work Order ID	103679
---------------	--------

Quality Control

June-24-13 2:1				^1():	36/9°							Page 2	
Item ID: Revision ID:	D2327-3		A	Accept	*N900	<b>040</b>	100	)* 5	Setup	Start	*N	S1*	
Item Name:	Spacer Bushi	ng		•						Stop	*N	S2*	
Start Date:	6/24/13	Start Qty: 40.00	*40*		Cust Item II	D:							
Required Date:	7/05/13	Req'd Qty: 40.00	*40*		Customer:								
Reference:								_	_	Q			
Approvals:	Process Pla	an:	Date:	Tooling:	Da	te:		1	Run	Start	*N	R1*	
	QC:	·	Date:	SPC (Y/N):	Da	ite:				Stop	*N	R2*	
Sequence ID/ Work Center I	<b>D</b>	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
130		Identify as per dwg & Stoc	k Location: WACC 4	0.00				. 1 -			1.0		
*130* Packaging		Memo		0.00				40>	<u> </u>		1/ <i>. LV</i> .	13-07-	2
Packaging		*****STOCK	IN BASKET CELL****										*
											1.	1.0	
*140 *1 <b>4</b> 0*		QC21- Final Inspection - \	Work Order Release	0.00						3/1	149	*	
QC 2 4		Memo		0.00						<del>- ' '</del> /	<u> </u>	<i>J</i>	

DQA:			Date:										TRAGG	
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFOI	RMANCE / UPDATE	Wo	ork Order up	odate only	AEROSPACE	
			•			DISPOSITION	•	AGAINST DEPARTMENT/PROCESS						
Work Orde						P avva et	1		Shirt Andre Conservation		1	14/o+a# (a+		
Part N	lo					Rework Scrap		1	Skid-tube Crosstube Water Jet  Machining Small Fab Prod. Eng. Coor.			Engineering Quality		
NCR N	1o. <u> </u>					Use-as-is Suspected Unapproved		Thermoforming Finishing Rec/Store/Packaging Large Fab Composite Supplier			Other			
Root					Desci	ription of work order update	1	nitial	Action		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
Design														
Doc/Data														
Equip/Tooling											İ			
Handling/Pre														
Material														
Operator														
Offset/Setup														
Process														
Supplier							l							
Training														
Transport														
Unapproved														
							FAI	ULT CAT	TEGORY					
Landi	ng Ge	ear			_	General		_			_		_	
	8	ending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced	
		entre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
		cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	ct	Temperature/Cure	
		rimp/Kir	ık/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld	
		Cuffs	-			Contamination		Instruct	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled	
		Crushing				Countersink		Misalig	gned/off center		Positioned V		<del></del>	
		leat Trea	t			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other	
		nspection	n Strip in	Tube		Drawing		Misread	d		-	_		•
	N	//arks/Ch	atter			Drill Holes		Off-set					· · · · · · · ·	•
	T	urning S	equence			Finish		Out of	Calibration					•
	$\Box$	Nave/Tw	ist in Tuk	ne .		Fit/Function		Out of	Seguence					•

June-24-13 2:11:48 PM

Work Order ID:

103679

Parent Item:

D2327-3

Parent Item Name:

Spacer Bushing

Start Date: 6/24/13

Required Date: 7/05/13

**Start Qty: 40.00** 

Required Qty: 40.00

Comments:

IPP F05.11.02Removed 303 SSKJ/EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304R0.375		Purchased	No		100	f	1.3640	0.1563	6.581052			

304 ROUND BAR 0.375

 Location
 Loc Qty
 Loc Code

 MAT029
 1.364

 125585
 1.364

126153

6.79 AS 13/07/02

DQA:			Date: _									
QA Closed:			Date:		WORK ORD	R NON-C	CONFO	RMANCE / UI		ork Order up	odate only	AEROSPACE
Work Orde	er:	. =			DISPOSITI	ON		AGAINST DEPARTMENT/PROCESS				
Part N				•	_	ework Scrap	<b>T</b> !	Skid-tube Crosstube  Machining Small Fab		Prod. Eng. Coor.		Engineering Quality
NCR N	lo				Suspected Unapp	e-as-is proved	Ther	moforming Large Fab	Finishing Composite	Rec/Sto	Other	
Root				C	Description of work orde	r update	Initial	Act	ion	Sign &	·	
Cause	D	ate	Step	Qty	or non-conforman	ce (	Chief Eng	Descr	ription	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved		•										
onapproved	L			<u> </u>		F/	AULT CA	 TEGORY		. L		
Landir	ng Gear	-			General					· · · · · · · · · · · · · · · · · ·		
	Cen Crac Crim Cuff Crus Hea Insp	cks hp/Kinl s hing t Treat hection ks/Cha	Strip in	/Wave	Bend BOM/Route Broken/Damage/D Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish	efect	Grain Hardw Inspec Instruc Misali Mislab Misrea Off-se	tion Incomplete/Un tions Incomplete/U gned/off center eled id	· —	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		_	· st in Tub	e	Fit/Function	·  -		Sequence			-	

DART AEROSPACE LTD	Work Order: 1036	79
Description: Spacer Bushing	Part Number: D2	327-3
Inspection Dwg: D2327 Rev: D	Page	e 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.375	+/-0.010	<b>375</b>	7		FK-04	Vern-
Ø0.257	+0.005/-0.000	, 258	7		J1	0
1.750	+/-0.010	1.758	7		h	h
PH - 177						
		···				

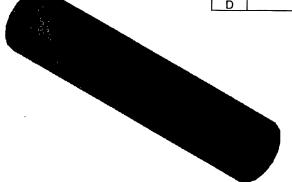
, S			
Measured by:	Audited by:	Prototype Approval:	N/A
Date: $\sqrt{3}/\sqrt{5}/02$	Date: パュースーユ	Date:	N/A

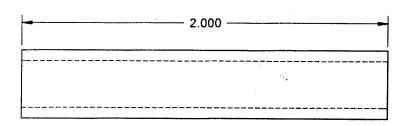
A         04.01.13         New Issue         KJ/RF           B         06.11.24         Dwg Revision revised         KJ/JLM	pproved	App	$\top$	evised by	Revis		Change	Date	Rev
1.0.02.11	<u> </u>		一十	/RF	KJ/Rf		New Issue	04.01.13	Α
C 08.01.28 Tolerance revised on Ø0.275			$\dashv$	/JLM	KJ/JL	evised	Dwg Revision revised	06.11.24	B *
KJ/EC/DD CKI	1/2		_	I/EC/DD	KJ/E(	ed on Ø0.375	Tolerance revised on Ø0	08.01.28	С

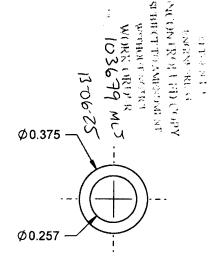


DESIGN BW	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA					
CHECKED	APPROVED	DRAWING NO. D2327	REV. D SHEET 1 OF				
DATE 06	.10.12	SPACER BUSHING	SCALE 2:1				

			<del></del>		
	REV	DATE	TE DESCRIPTION		
	Α	94,12.17	NEW ISSUE		
	В	95.12.06	LENGTH CHANGE		
	С	03.05.13	303 SS SPEC ADDED		
	D	06 10 12	REMOVE 303 SS MATERIAL		

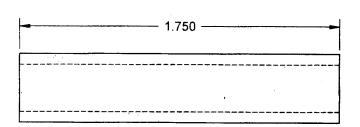


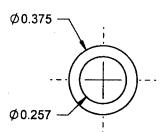




RELEASED

## **D2327-1 SPACER BUSHING**





## **D2327-3 SPACER BUSHING**

1) MATERIAL: AISI 304/316 SS, Ø0.375, 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC M304TR0.375W.065)



2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
5) BREAK ALL SHARP CORNERS TO 0.010 MAX

**COPYRIGHT © 1994 BY DART AEROSPACE LTD** 

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

ALC:	1 行用 43	· 10. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1. 1.		1000
	engi Ma	- 日本 <b>は1985年後の東京</b> (1987年) - 1987年 - 1		
	Test			20 <b>3</b>
				- 2
				: []
<b>Y</b>				
	č.			
	ħ.			
				, x
			5.1	
e				
- 	41			38
	7.1			ä
<del>-</del>				ļ
	- 12. 			
à	,e-		!	
. "	- 12 TH			
	4.3			Į,
	# 1 1 4 1 4			l.
	1			
	27 tu			:
14.				ľ
				•
r est				
g <b>a</b> g - 1 <b>8</b>				
	, <u>, , , , , , , , , , , , , , , , , , </u>			
	e concentit i i.i.d	The state of the s		